



Dart Aerospace Ltd.
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D2154
Job Sheet 202854



Part No: D2154

Job Qty: 12 pcs

Part Name: Bracket, Stud



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/5/19

Job Tracking No:

Due Date: 11/29/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP: C 03.08.08 Reformat; Remove Tumble KJ/RF IPP Rev:D NowOn Waterjet 07-04-09 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	12 pcs		11/29/19	0.17	0.56	Waterjet - Flow		JRB 11/12/19
120	QC 8	12		11/29/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		
							QC 8 - 61		
140	Small Fab - Brake NC - B4B	12 pcs		11/29/19	0.25	0.30	Small Fab - Brake - 1 - B4B		
							Small Fab - Brake - 2 -		

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Container No: S230769
Part: D2154
Job No: 202854
Serial No/Batch: S230769
Revision:
Inspector:
Exp Date:
Instructions: Various STC's

Date: 11/12/19

DAS
40
9-89

NOV 13 2019

DAS
30
9-89
DEC 23 2019

				B4B	
				Small Fab - Brake - 3 - B4B	
150 QC 5	12 pcs	11/29/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	DEC 3 1 2019
160 Powdercoat - 2 White GI(S)- B4B	12 pcs	11/29/19	0.00 0.14	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	20-01-8
				Powdercoat - 4 - B4B	
170 QC 3	12 pcs	11/29/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
180 Packaging 3-1 - Stock - B4B	12 pcs	11/29/19	0.00 0.00	QC 3 - 24	DAS 81 9-89
				QC 3 - 61	
				QC 3 - 81	JAN 0 0 2020
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	✓ ST002 DAS 80 9-89
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	JAN 1 0 2020
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	

DAS 81 9-89

DAS 82 9-89

				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	20 pcs	11/29/19	0.00 0.00	QC 21 - SA - 21	ST002
				QC 21 - SA - 70	
				QC 21 - SA - 53	
Part Op 100 - 1-Cut as per Dwg D2154					
Descriptions: 120 - (QC8- Inspect parts - second check)					
140 - (Bend/Assemble as per dwg) Form as per Dwg D2154					
150 - (QC5- Inspect part completeness to step on W/O)					
160 - (White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel) START TIME: 11:35 FINISH TIME: 12:05					
170 - (QC3- Inspect Part Finish)					
180 - (Identify as per dwg & Stock Location:)					
190 - (QC21- Final Inspection - Work Order Release)					
JAN 10 2020					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M304S16GA	304/316 Sheet .063	.3996 sf (.0333 ea)	100-Waterjet - Flow - 1	5207058	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Waterjet - Flow - 1	M304S16GA	0	275	0	

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket, Stud	2.250Inches ± 0.010	2.260 2.240	2.256	
2	Bracket, Stud	1.438Inches ± 0.010	1.448 1.428	1.439	
3	Bracket, Stud	0.406Inches ± 0.010	0.416 0.396	0.407	
4	Bracket, Stud	1.778Inches ± 0.010	1.788 1.768	1.782	
5	Bracket, Stud	2.128Inches ± 0.010	2.138 2.118	2.127	
6	Bracket, Stud	0.325Inches ± 0.010	0.335 0.315	0.325	
7	Bracket, Stud	0.203Inches + 0.005 - 0.001	0.208 0.202	0.204	Diameter
8	Bracket, Stud	0.063Inches ± 0.010	0.073 0.053	0.066	
9	Bracket, Stud	0.320Inches + 0.006 - 0.001	0.326 0.319	0.323	Diameter

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)			
Description Work Order Deviation		Disposition					
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY Pressure/Forced ☐ Contamination ☐ Power Loss/Surge ☐ Bending ☐ Misaligned/off center ☐ Folio/Program ☐ Crushing ☐ BOM/Route ☐ Grain Direction ☐ Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Incomplete/Unclear Instructions ☐ Wrong Stock Pulled ☐ Marks/Chatter ☐ Drill Holes ☐ Out of Sequence ☐ Mislabeled ☐ Fit/Function ☐ Off-set/Set-up ☐ Other/Details:				Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐	
		Completed By				Lead hand / Supervisor	
		QC / QA Coordinator					